Work Orde Wednesday, Sept												Page 1
Revision ID:	D3535-25 Wearshoe			Accept					Setup	Start Stop		
	9/22/2010	Start Qty: 10.00 Req'd Qty: 10.00			Cust Iten Customer					•		
Approvals:	Process Pla	n:	Date: <u>/ O- 9- 23</u> Date:	Tooling:  SPC (Y/N):		Date:			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr B										
Waterjet FLOW CNC Waterjet 304. 040	et	FLOW WATER JET  Memo 1-Cut as p Deburr if  QC2- Inspect parts off	necessary	0.00 ev:□Prog Rev:	<b>B</b> _02-			_B	(O- °	<u>}- 3</u> ⊘	(jc	D :
QC Quality Control		Мето	· ·	0.00				B	10-9	-34)		; · ·
120 QC		QC8- Inspect parts - se	econd check	0.00 E 10 ( co	olo(			FNY	)		-	

Quality Control

W/O: DATE STEP	PRC	W OCEDURE CH	ORK ORDER CHANG			Approval	
DATE STEP	PRC	OCEDURE CH	ANCE			Annroval	
		ANGE	Ву	Date Qty	Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:	PAR #:	Fault Cat	tegory:	_ NCR: Yes	No DQA:	Date: _	
Resolution	1:	Dispositi	on:	_ QA: N/C Cld	osed:	Date: _	
NCR:		WORK OR	DER NON-CONFORMA	ANCE (NCR	)		
DATE STEP	Description of NC			ion B	Verification		Approval
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		·					
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#### Work Order ID 62233

Wednesday, September 22, 2010 3:31:12 PM



Page 2

Item ID:

D3535-25

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: Wearshoe

**Required Date: 9/29/2010** 

**Start Date:** 9/22/2010

**Start Qty: 10.00** 

Req'd Qty: 10.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Date:\_\_\_\_\_

Tooling:

Date:

Date:

Start Run

Set Up/

SPC (Y/N):

**Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Stop

Insp. Number Stamp

130

Sequence ID/

Work Center ID

Brake NC Brake NC

NC BRAKE

Operation

Description

Memo

Memo

0.00

0.00

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 S

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 pd/0-10-7.

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per OS1005 4.3

0.00

OOVEN TEMPERATURE:

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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#### Work Order ID 62233

Wednesday, September 22, 2010 3:31:12 PM



Page 3

Item ID:

D3535-25



Setup Start

Stop



**Revision ID:** 

Item Name: Wearshoe

**Start Date:** 9/22/2010 **Required Date: 9/29/2010**  **Start Qty: 10.00** 

Req'd Qty: 10.00



Accept

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

Date:

Date:

Start

Stop

Run



Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Work Center ID

160

Sequence ID/



Quality Control

Operation Description

QC3- Inspect Part Finish

Folwlos &

170

Packaging Packaging

Memo

Memo

Identify as per dwg & Stock Location: F7/8

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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W/O:			WO	RK ORDER CHANGE	S	,								
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Resolution:			Disposition	:	QA: N/C C	osed:		Date: _						
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	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Secti	on C	Chief Eng	QC Inspector					
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### **Picklist Print**

Wednesday, September 22, 2010 3:32:24 PM

Work Order ID: 62233

Parent Item:

D3535-25

Parent Item Name: Wearshoe



Start Date: 9/22/2010

Required Date: 9/29/2010

**Start Qty: 10.00** 

Required Qty: 10.00

**Comments:** 

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	33.3987	0.51	5.368421	7.2 1810-	9-36	د

Loca	tion	Loc Oty	Loc Code		
MAT	,	10.6522			
	114574	10.6522			(17
MAT	20	22.7465		<u></u>	( '
	112885	2.7475			
	113062	0.699			
	115440	19.3			
	115762			115767	

rospace	Ltd								r i
		WO	RK ORDER CH	ANGES					
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DART AEROSPACE LTD	Work Order:	42233
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1,891	7		V B02	
1.937	+/-0.010	1.957	9		V	
1.450	+/-0.010	1.450	7		V	
5.450	+/-0.010	5,450	R		J	
10.900	+/-0.010	10,900	×		7 1301	!
16.350	+/-0.010	16,350	>		٦	**
21.800	+/-0.010	21.800	9		7	
Ø0.188	+0.005/-0.001	, 190	4		V	
12.750	+/-0.010	12.750	<u>}</u>		τ	
6.75	+/-0.030	6,748	<b>y</b>		V +1802	
6.00	+/-0.030	6,000	ŷ		V	
0.300	+/-0.010	.301	Xb		V	
0.300	+/-0.010	307	<b>&gt;</b>		V	
0.038	+/-0.010	038	*		V	
				-		

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-36	Date:	iololos	Date:	N/A

Rev	Date	Change	Revised by Appr	oved
A	07.11.23	New Issue	KJ/EC/DD	
			70	

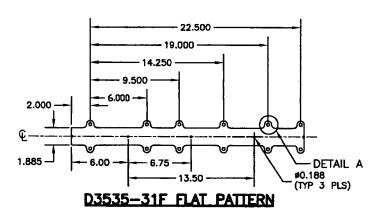
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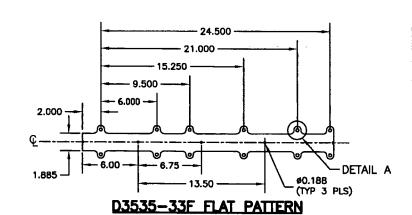






D3535-31 BEND DETAIL

Wa 42233





D3535-33 BEND DETAIL

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AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 CAUGE (0.038 THICK) 1) MATERIAL:

(REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER

QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT Q
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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AEROSPACE PORT HADLOCK,

USA,

NC.

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SHEET

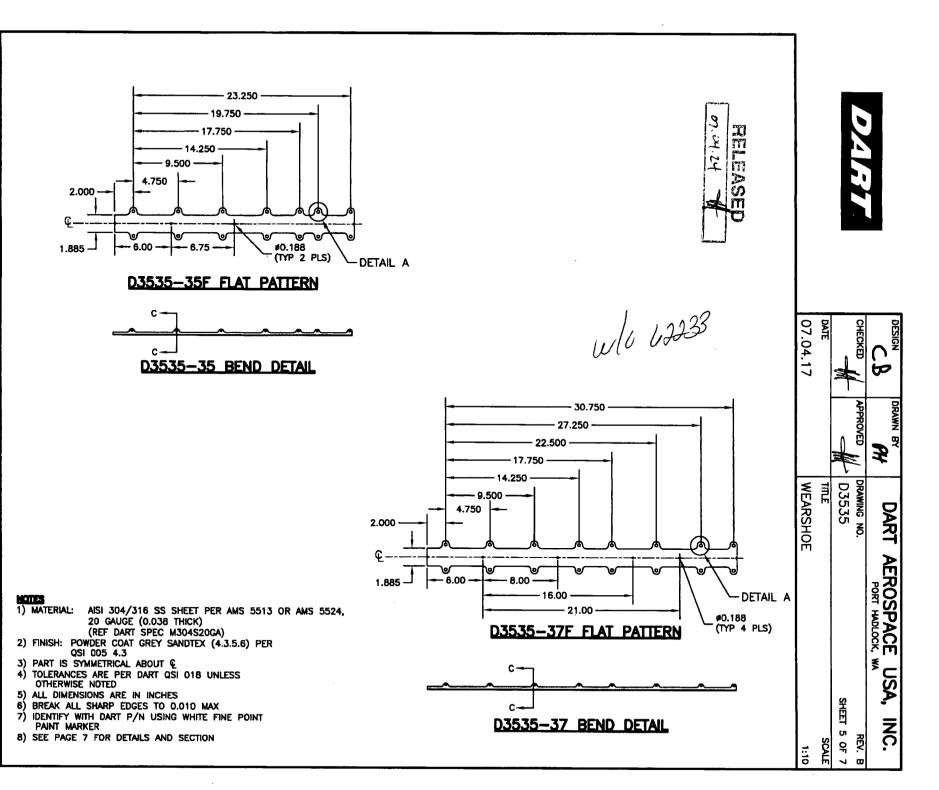
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WEARSHOE

DATE 07.04.17

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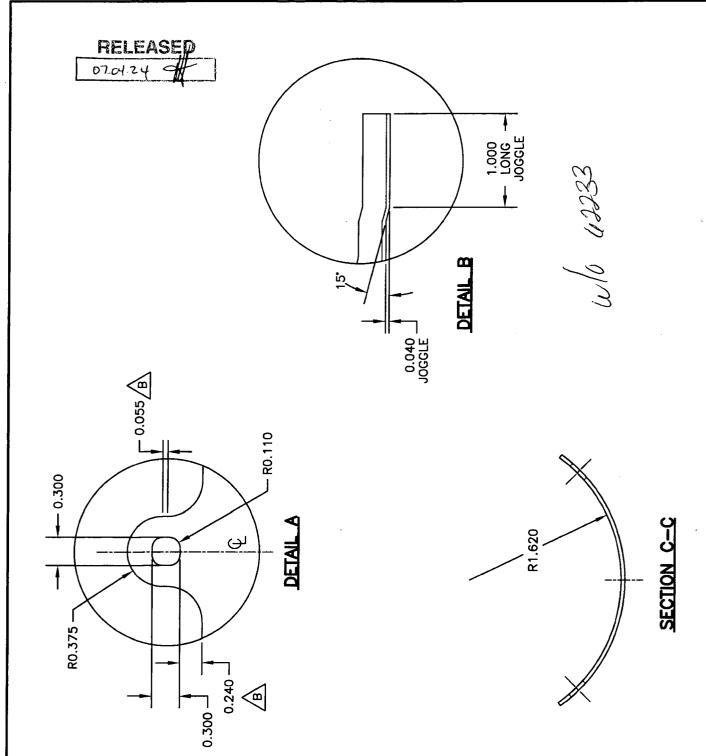
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07.04.17		WEARSHOE	1:1



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